

Date: Monday, 20/04/2009 9:58:51 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GUSSET ASS'Y
 Job Number : 47273
 Estimate Number : 13865
 P.O. Number :
 This Issue : 20/04/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D3929041
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3929 PRELIMINARY
 Previous Run : Project Number : N/A
 Material :
 Due Date : 27/04/2009 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : JUD 09-04-20
 Comment : Est Rev:A 09-04-20 new issue EC verified by:DD

Additional Product

PRELIMINARY ISSUE

P22 ECN # 09-5708

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S220A 304/316 .040 Sheet
r125

09-04-20 MAT NOT PULLED



Comment: Qty.: 0.4725 sf(s)/Unit Total: 0.9450 sf(s)

304/316 .040 Sheet 0.125 thick

Batch: 111018 B9-4-20

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3929

Dwg Rev: P22Prog Rev: Lim

B9-4-20

2

2-Deburr if necessary

B9-4-20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B9-4-20



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



09-04-21 2



Comment: SECOND CHECK

5.0 D39071 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bushing

Batch: 647105

PD 09-04-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 20/04/2009 9:58:51 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUSSET ASSY

Job Number: 47273

Part Number: D3929041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M108160

PD 09-04-21 (2)

7.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

CP 09-04-21 (2)

8.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify as per dwg and Stock

Location: _____

PPP 47636 x1 ST139C x1

SS 09/04/30 (2)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/04/30

Job Completion



MF 09-04-30

POSITIVE RECALL
EFFECTIVE 09-04-20 AUTH
DATE 09-04-21

Dart Aerospace Ltd

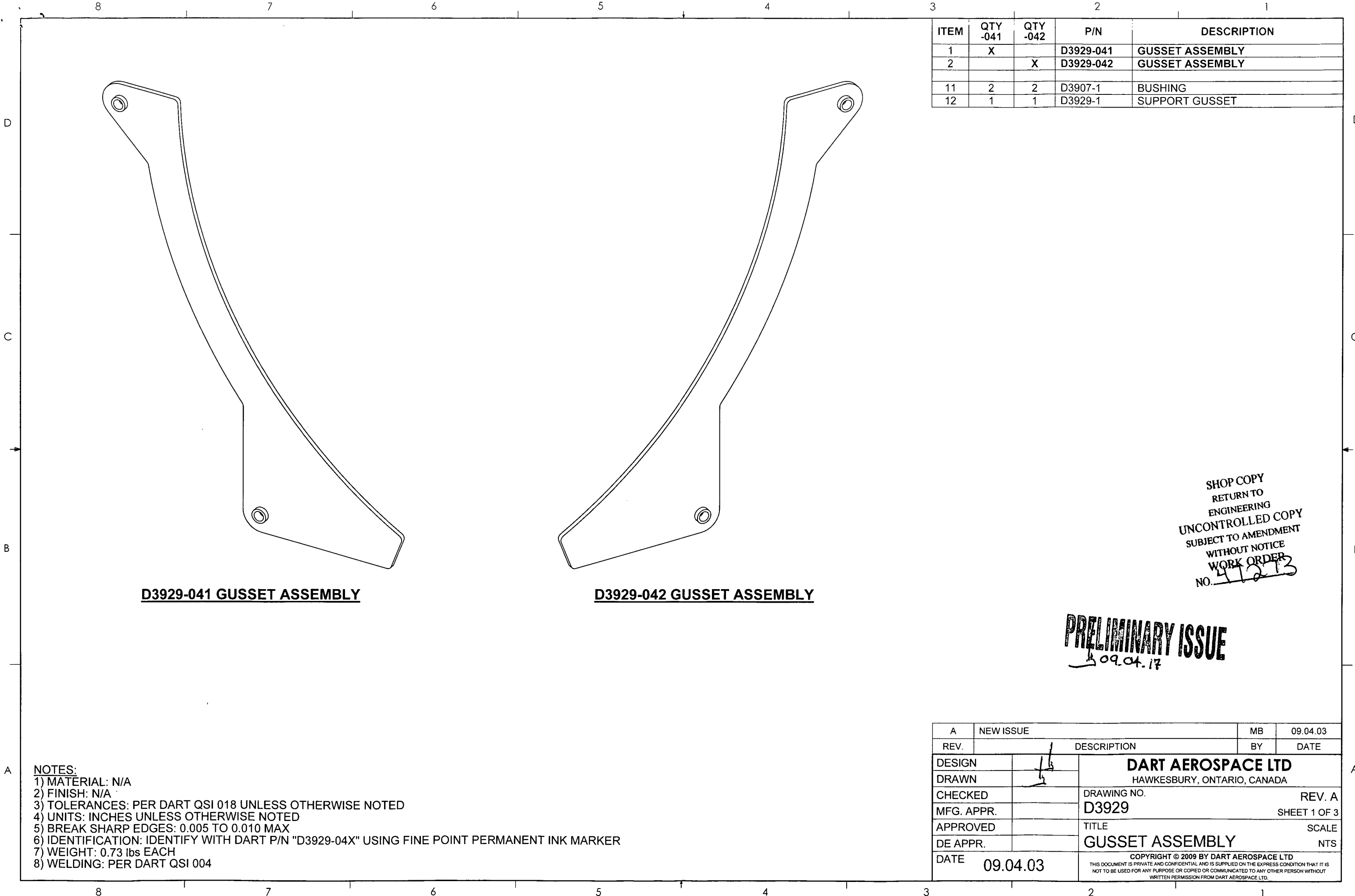
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

D3929-041 GUSSET ASSEMBLY

D3929-042 GUSSET ASSEMBLY

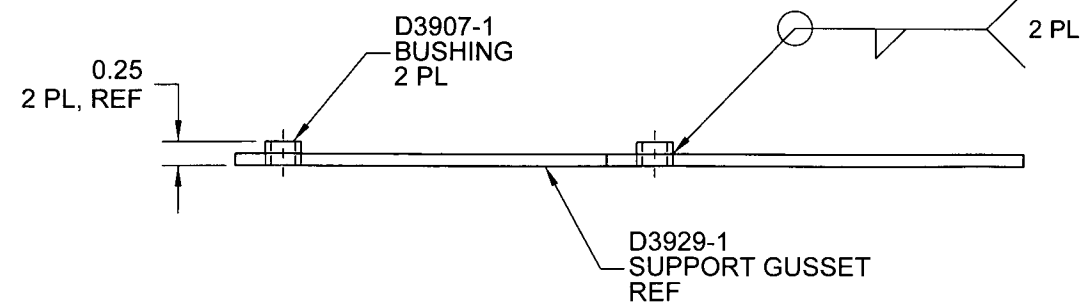
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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41213

PRELIMINARY ISSUE
09.04.17

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

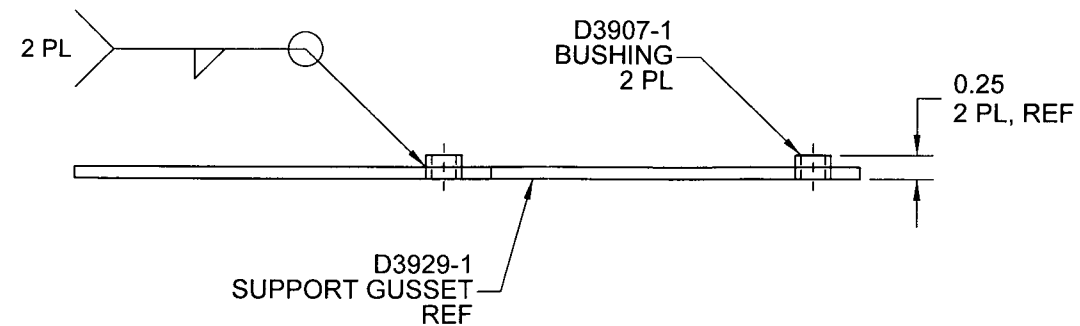
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REV.	DESCRIPTION	BY	DATE
DESIGN	13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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D3929-1
SUPPORT GUSSET
2 PL



D3929-041 GUSSET ASSEMBLY

D3929-1
SUPPORT GUSSET
2 PL



D3929-042 GUSSET ASSEMBLY

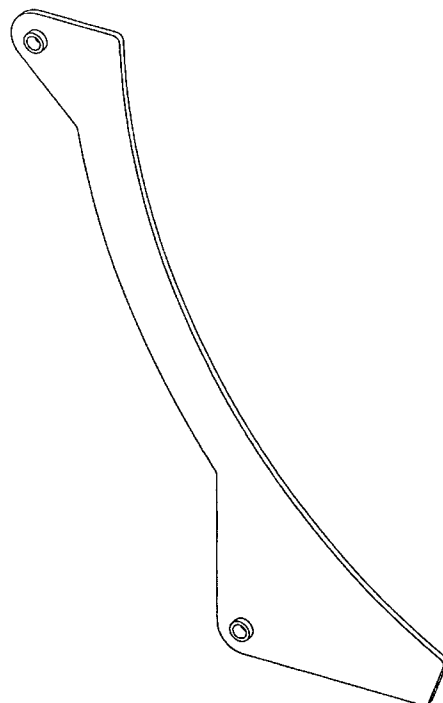
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WORK ORDER
NO. 4723

PRELIMINARY ISSUE
09.04.17

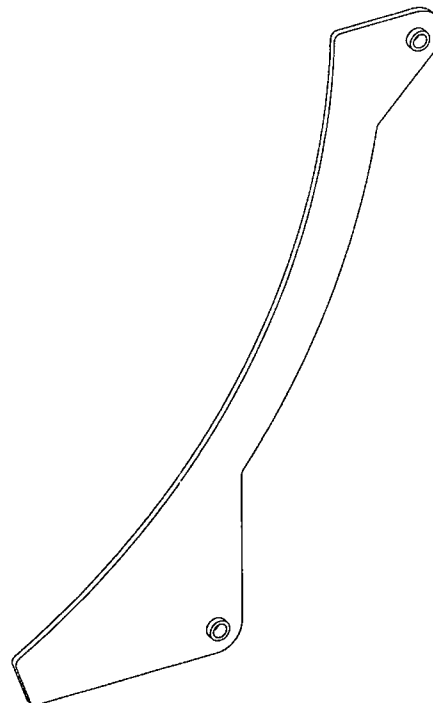
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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

47273

RELEASED
8/10/12 MD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
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APPROVED			
DE APPR.			
DATE	09.04.03		

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TITLE GUSSET ASSEMBLY	SCALE NTS
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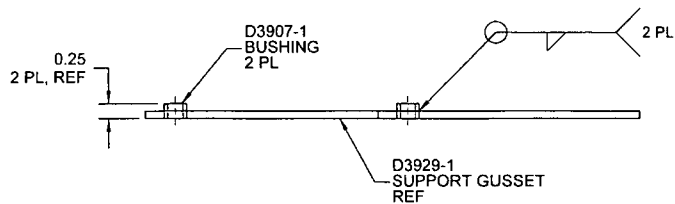
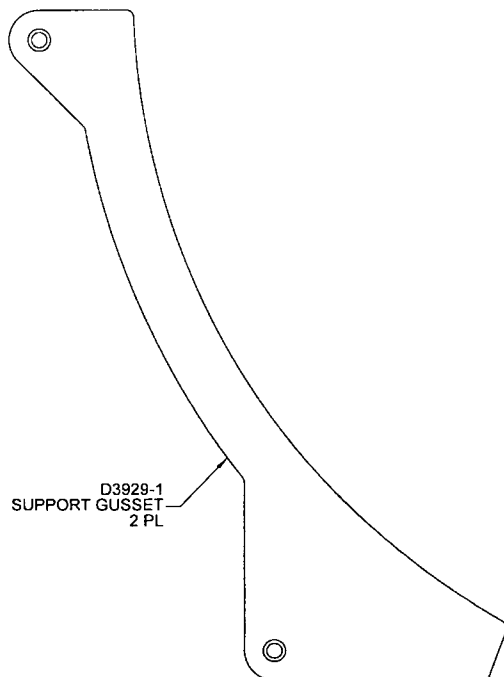
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**D3929-041 GUSSET ASSEMBLY**

47273

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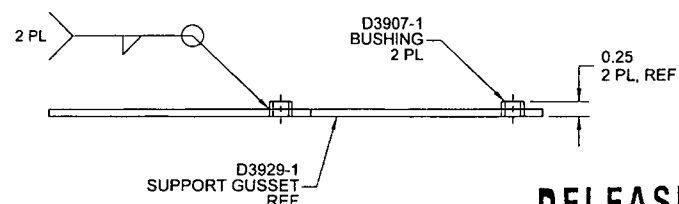
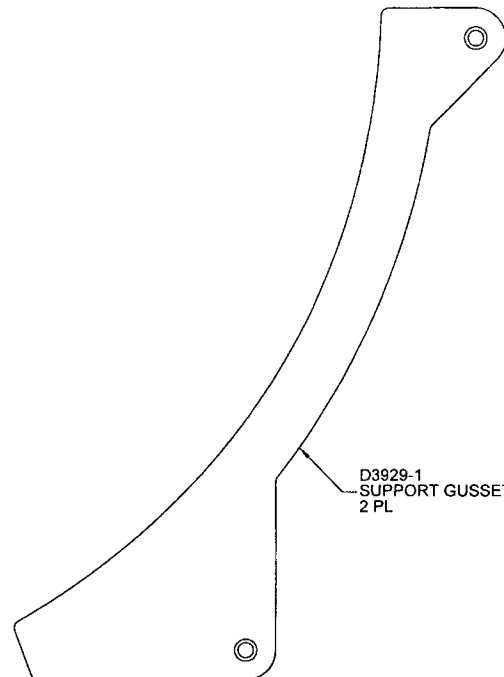
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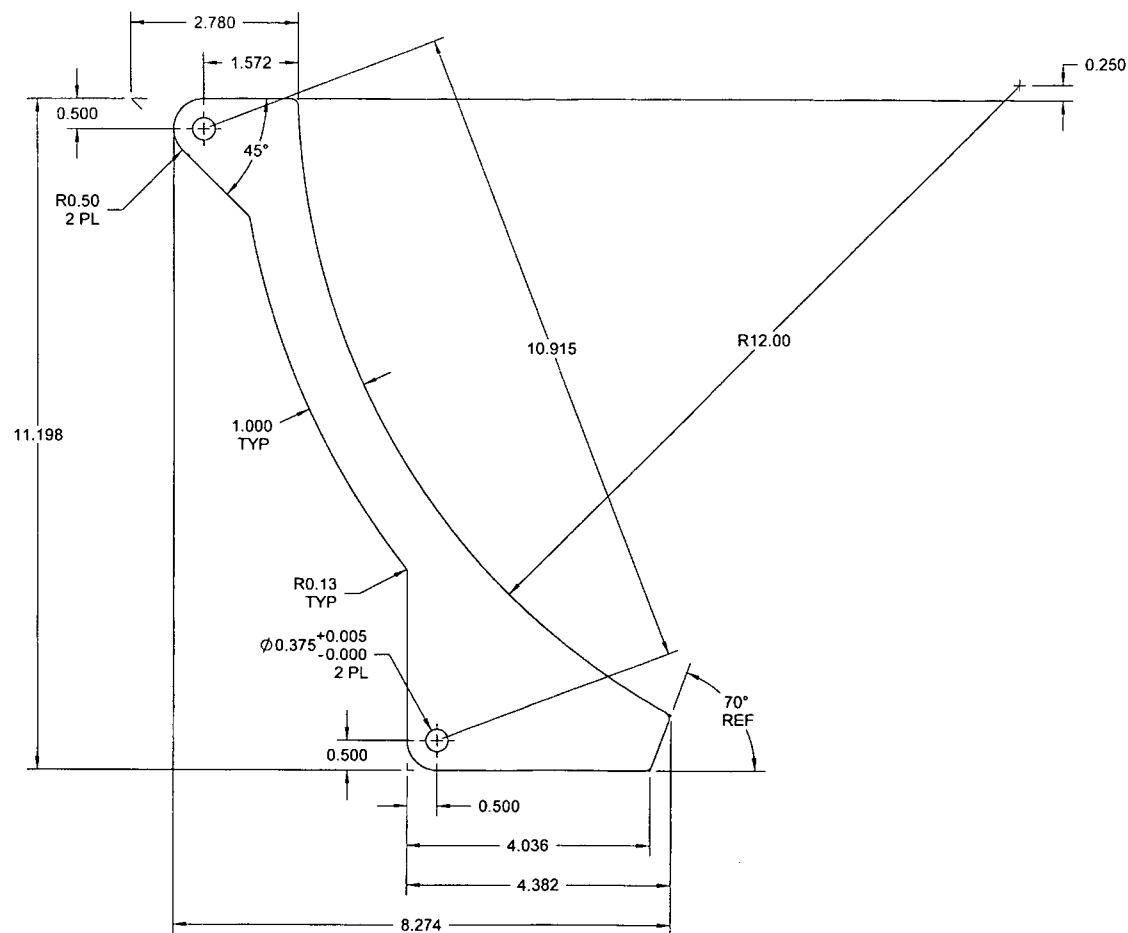
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**D3929-042 GUSSET ASSEMBLY****RELEASED**
09/04/22

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D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

47273

RELEASED
09/04/22-11/22

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